

Date: Friday, 17/08/2007 11:21:59 AM
 User: Linda Lacelle

Process Sheet

*split into
 8/09/06*

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE
Job Number : 34105	
Estimate Number : 12171	
P.O. Number : <i>NIA</i>	Part Number : D34767
This Issue : 17/08/2007 S.O. No. : <i>NIA</i>	Drawing Number : D3476 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : SMALL/MED FAB	Drawing Revision : A
Previous Run : 32052	Material : <i>NIA</i>
Written By : <i>[Signature]</i>	Due Date : 11/09/2007 Qty: <i>2</i> Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 06-02-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.1072 sf(s)/Unit Total : 0.6432 sf(s)

Pick:

304/316 0.018 SHEET

(M304S26GA)

Batch: *M105490*

FF 07-09-05 6

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR

Cut Flat pattern as per Dwg D3476

FF 07-09-05 6

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Roll as per Dwg D3476

3-Form Bead as per Dwg D3476 Using Rotary Machine.

4-Spot Weld as per Dwg D3476 and Dart QSI 018

5-Cut 69 Deg Angle as per Dwg D3476.

MF 07-09-06

MF 07-09-06

LMF 07-09-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

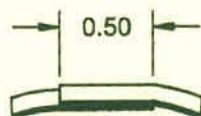
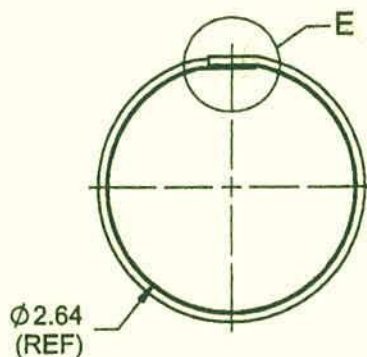
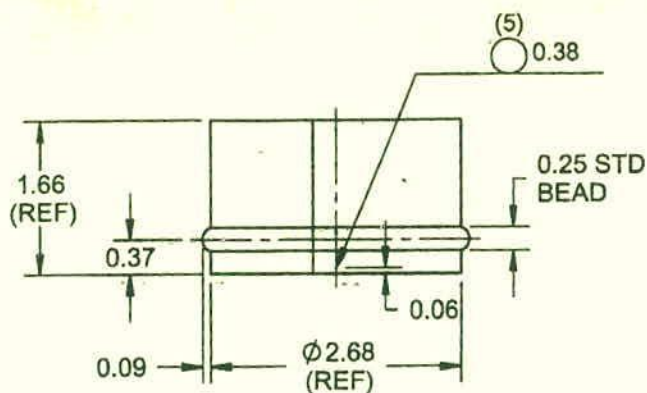
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



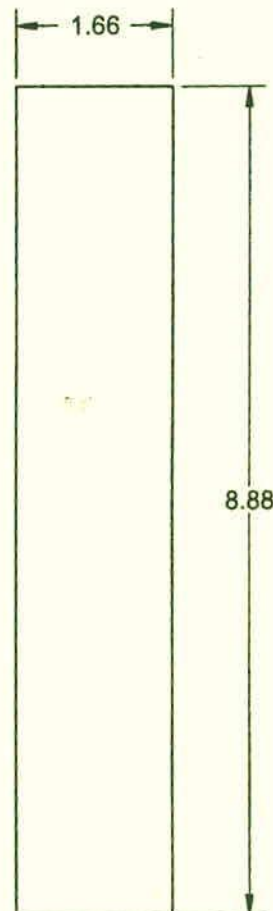
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3476	REV. A SHEET 7 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

[Signature] 06.04.03



DETAIL E
SCALE 1:1

D3476-7 TUBE



D3476-7 TUBE FLAT PATTERN

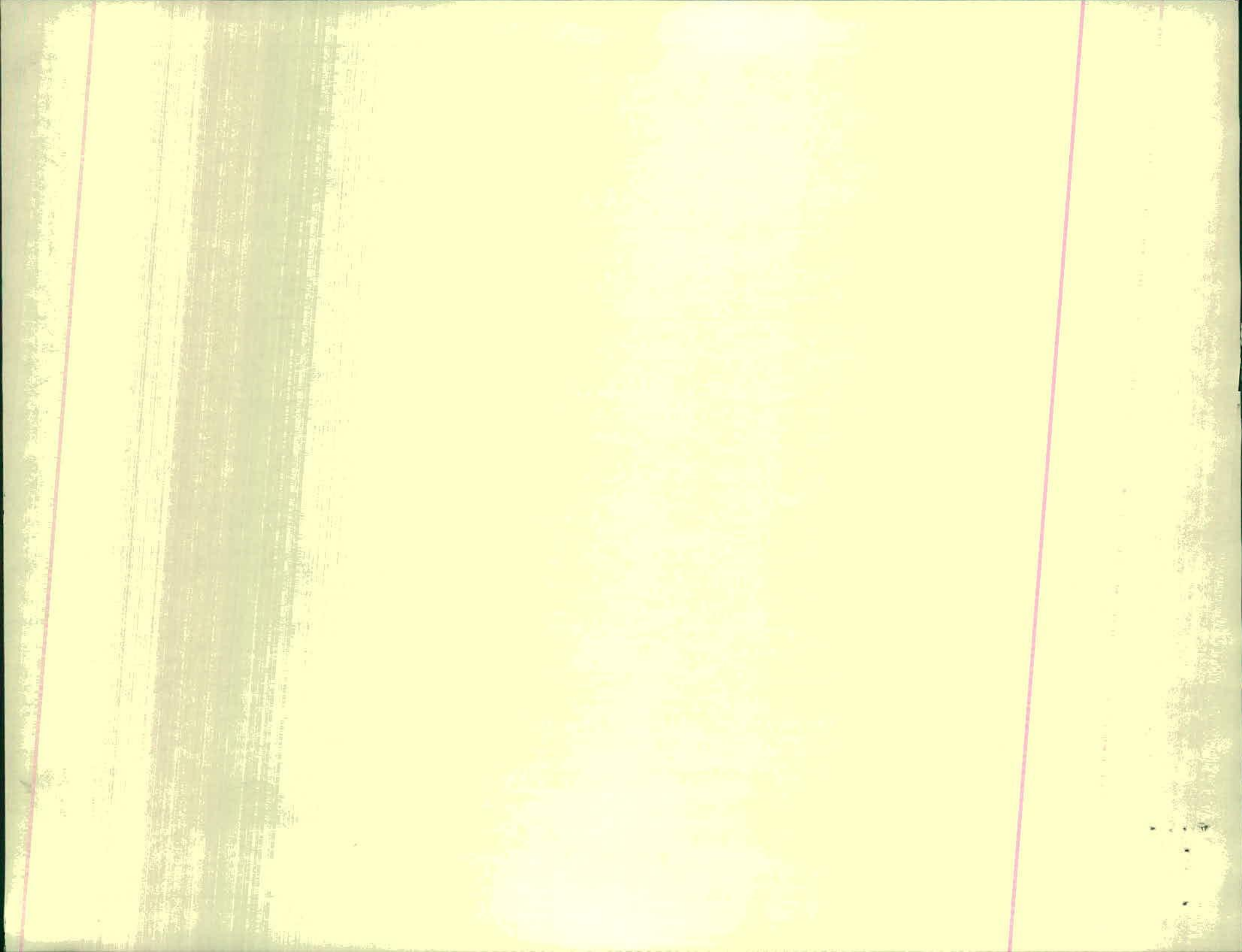
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *34105*

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 4

EMPLOYEE: Melanie Fawcett

PART NUMBER: D 3476-7

JOB NUMBER: B 34105

MATERIAL TYPE: 304 L

MATERIAL THICKNESS: 0.08

GROUP SPECIFICATION

- ☐ Group 1: Aluminum & magnesium
☐ Group 2: Iron; nickel; cobalt
☐ Group 3: Titanium

TEST RESULTS

	PASS	FAIL
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PENETRATION:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/07/00
QUALIFIER: SB

